

Toship Sept 28.

Work Order ID 136751

136751

September 03, 2015 3:05:05 PM

Page 1

Item ID: D350-607-543 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Quick Release Heli-Utility-Basket™ Long,Light Lid, Spacepod™/Squirrel Cheek Comp
 Start Date: 9/3/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/21/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SH Date: 0150903 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	D								
DSI9699	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-543 CHG008								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***								

Auto Label

BAS
27
9-89

MCS 15-09-23

BAS
02
9-89

SEP 24 2015

BAS
27
9-89

SEP 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

136751

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/3/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/21/2015 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

inspect label

DAS
38
9-89
SEP 24 2015

117

Pick Kit

0.00

117

Packaging

Memo

0.00

Packaging

DAS
27
8-83

SEP 24 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
02
9-89

SEP 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																			
Misidentified ☐	Past Due ☐																				

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Item ID: D350-607-543

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Stop ***NS2***

Start Date: 9/3/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/21/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 02 9-89
130									
Packaging	Memo	0.00							
Packaging	Package as per PPPD350-607-543								
SEP 24 2015									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									
SEP 25 2015									

2015-09-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VRF BY:EC IPP
REV:B 12.03.06 AS PER ECN12-535 DD VRF:EC IPP REV:C
12.07.24 AS PER ECN 12-610 DD VRF:EC IPP Rev:D 13.07.08 as
per CHG005 (ECN13-582) DD vrf:JLM IPP REV:E 13.08.21 CHG006 /
ECN 13-624 DD VRF:JLM IPP REV:F 14.06.09 AS PER ECN14-572
DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4917-315		Manufactured	No				Each	16.0000		1			9-89
D4917-315									**			DAS 27 9-89	
Placard, Max Load	DAS 02 9-89												
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				st138				16					
				127796				4					
				134787				12					
D350-607-511		Manufactured	No				Each	0.0000		1			9-89
D350-607-511	DAS 02 9-89								B133389**				
Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH													
D2690-6		Manufactured	No				Each	32.0000		1			9-89
D2690-6	DAS 02 9-89								**			DAS 27 9-89	
Lanyard													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST009				32					
				134004				10					
				135768				22					

SEP 23 2015

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

D3912-041 Manufactured No

Each 15.0000 Start Qty: 1.00

Required Qty: 1.00

D3912-041

Eyebolt Receiver Assy

DAS
02
9-89

Location

Loc Qty

Loc Code

ST057

8

~~131683~~

2

135344

6

ST064A

6

133897

6

ST065

1

127771

0

128790

1

**

DAS
27
9-89

DAS
6
9-89

D4030-043 DAS 02 9-89 Manufactured No

D4030-043

Long Basket Assembly, Light Lid (350)

Each 0.0000

1

**

136761

DAS
6
9-89

D4086-215 Manufactured No

Each 13.0000

1

**

D4086-215

Placard Max Load

DAS
02
9-89

Location

Loc Qty

Loc Code

ST087

13

~~110331~~

1

117191

12

DAS
27
9-89

DAS
6
9-89

SEP 23 2015

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

D4151-041 Manufactured No

Each 10.0000 Start Qty: 1.00 1

Required Qty: 1.00

D4151-041

Basket Fwd Hardpoint Assembly, Lower

DAS
02
9-89

Location	Loc Qty	Loc Code
ST096	2	
136398	2	
ST103a	8	
129716	1	
<u>130865</u>	2	
131723	1	
132435	2	
134304	2	

**

DAS
27
9-89

D4151-043 Manufactured No

Each 7.0000 Start Qty: 1.00 1

D4151-043

Basket Fwd Hardpoint Assembly, Upper

DAS
02
9-89

Location	Loc Qty	Loc Code
ST096	3	
131134	3	
ST103a	4	
130050	4	

**

DAS
27
9-89

D4150-041 Manufactured No

Each 11.0000 Start Qty: 1.00 1

D4150-041

Attachment Arm Assembly

DAS
02
9-89

Location	Loc Qty	Loc Code
ST095	1	
128454	1	
ST103a	10	
129856	2	
<u>131833</u>	4	
132579	2	
134404	2	

**

DAS
27
9-89

SEP 23 2015

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

AN4-13A

Purchased No

Each

Start Qty: 1.00
246.0000 6

Required Qty: 1.00

AN4-13A

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

ST344

226

m132551

226

AN4C15

Purchased No

Each

26.0000

1

AN4C15

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST312A

26

M128936

26

AN310C4

Purchased No

Each

62.0000

1

AN310C4

Nut

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST331

62

M131305

12

M132344

50

SEP 23 2015

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long,Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

MS17984-C413

Purchased

No

Each

Start Qty: 1.00
35.0000 1

Required Qty: 1.00

MS17984-C413

Quick Release Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

ST260a

8

m132677

8

ST312A

23

m132570

11

m133031

12

ST315

4

m132852

4

**

DAS
27
9-89

DAS
6
9-89

MS21042L4

Purchased

No

Each

2,170.000

6

MS21042L 4

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1886

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1706

**

DAS
27
9-89

DAS
6
9-89

SEP 23 2015

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long,Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

MS24665-151

Purchased

No

Each

Start Qty: 1.00
164.0000

Required Qty: 1.00

MS24665-151

Cotter Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

GA	59	
m128401	59	
ST294	105	
m128401	9	
<u>m129909</u>	96	

**

DAS
27
9-89

NAS1515H4L

Purchased

No

Each

193.0000

***NAS1515H4I ***

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

FG	22	
103691	2	
m132189	20	
ST266	171	
m132189	44	
<u>m132767</u>	127	

**

DAS
27
9-89

NAS1149F0432P

Purchased

No

Each

950.0000

NAS1149F0432P

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

ST260a	500	
M132551	500	
st268	450	
M128995	63	
M130388	8	
<u>M132677</u>	379	

**

DAS
27
9-89

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Work Order ID: 136751

136751

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Check
Comp

Start Date: 9/3/2015

Required Date: 9/21/2015

NAS1149C0463R

Purchased

No

Each

Start Qty: 1.00
328.0000 3

Required Qty: 1.00

NAS1149C0463R

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

76

m127306

76

ST271

252

m128401

152

m133077

100

DAS
27
9-89
SEP 23 2015
DAS
6
9-89

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6

REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

136751 SN 20150903

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
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3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

- 3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.
- 3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).
- 3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

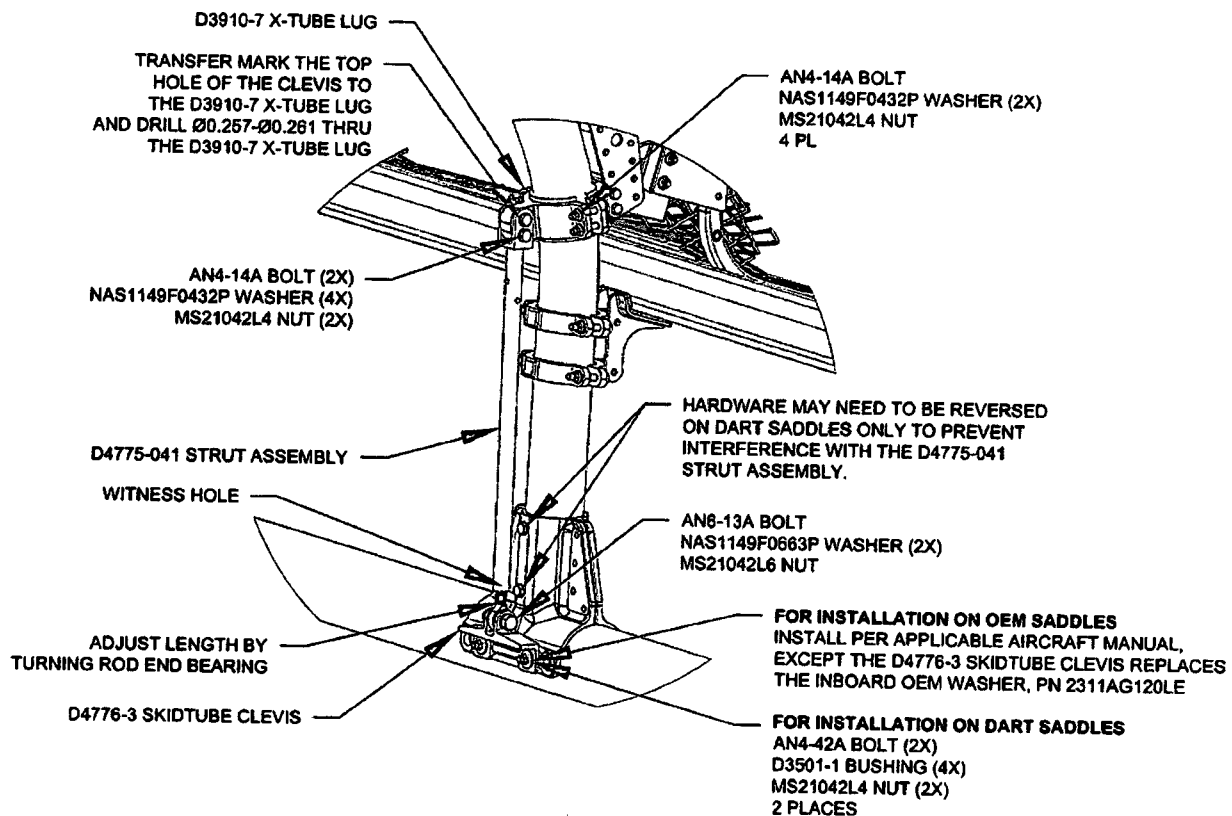


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

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02
9-89

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D350-607-3
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5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

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Revision: D
Date: 14.01.02

REFERENCE ONLY

DAS
02
9-89**DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

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